

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 96391

Monday, January 28, 2013 9:21:27 AM

96391

Page 2

Item ID: D4640-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Protector
 Start Date: 1/28/2013 Start Qty: 13.00 ***13*** Cust Item ID:
 Required Date: 2/11/2013 Req'd Qty: 13.00 ***13*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo USE TEMPLATE TO MARK HOLE LOCATIONS WITH A FINE POINT MARKER ON TEXTURED SIDE	0.00 0.00		<i>Smp</i> <i>13.2.20</i>		<i>8</i>			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location <i>PK</i> Memo	0.00 0.00				<i>8</i>		<i>13/2/25</i>	<i>DAS</i> <i>06</i> <i>8-88</i>
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<i>ML5 13-02-25</i>	

u 13-02-25

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Picklist Print

Monday, January 28, 2013 9:21:32 AM

Page 1

Work Order ID: 96391

96391

Parent Item: D4640-11

D4640-11

Parent Item Name: Floor Protector

Start Date: 1/28/2013

Required Date: 2/11/2013

Start Qty: 13.00

Required Qty: 13.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.093-F6006-07

Purchased

No

100

sf

1,261.600

16

~~218.9474~~

MI FXS 093-F6006-07

220

Jm.3-2-19

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT023

1261.6

114459

229.26

123105

1032.34

123105

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DART AEROSPACE LTD		Work Order: 9639
Description: Floor Protector		Part Number: D4640-11
Inspection Dwg: D4640	Rev: PA	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50 ✓	+/-0.030	3.50"	-		V	Item 1
25.42 ✓	+/-0.030	25.42"	-		T	Item 6
27.86 ✓	+/-0.030	27.86"	-		T	
31.36 ✓	+/-0.030	31.36"	-		T	
49.96 ✓	+/-0.030	49.96"	-		T	
53.46 ✓	+/-0.030	53.46"	-		T	
55.90 ✓	+/-0.030	55.90"	-		T	
62.11 ✓	+/-0.030	62.11"	-		T	
63.61 ✓	+/-0.030	63.61"	-		T	
73.08 ✓	+/-0.030	73.05"	-		T	
76.55 ✓	+/-0.010	76.55"	-		T	
78.05 ✓	+/-0.030	78.05"	-		T	
80.80 ✓	+/-0.030	80.80"	-		T	
0.88 ✓	+/-0.030	0.88"	-		V	
4.21 ✓	+/-0.030	4.21"	-		V	
5.02 ✓	+/-0.030	5.02"	-		V	
8.59 ✓	+/-0.030	8.59"	-		V	Production
10.65 ✓	+/-0.030	10.65"	-		V	
14.22 ✓	+/-0.030	14.22"	-		T	
15.03 ✓	+/-0.030	15.03"	-		T	
17.62 ✓	+/-0.030	17.62"	-		T	
0.37 ✓	+/-0.030	0.37"	-		V	
1.84 ✓	+/-0.030	1.84"	-		V	
3.67 ✓	+/-0.030	3.67"	-		V	
3.76 ✓	+/-0.030	3.76"	-		V	
4.59 ✓	+/-0.030	4.59"	-		V	
8.59 ✓	+/-0.030	8.59"	-		V	
10.65 ✓	+/-0.030	10.65"	-		V	
14.64 ✓	+/-0.030	14.64"	-		T	
15.48 ✓	+/-0.030	15.48"	-		T	
15.57 ✓	+/-0.030	15.57"	-		T	
17.40 ✓	+/-0.030	17.40"	-		T	
18.87 ✓	+/-0.030	18.87"	-		T	
19.24 ✓	+/-0.030	19.24"	-		T	
0.093 ✓	+/-0.010	0.091"	-		V	

Measured by: Jm	Audited by: SMD	Preliminary Approval:
Date: 13-2-19	Date: 13/2/20	Date:
Rev	Date	Change
A	12.09.26	New Issue
Revised by: KJ		Approved:

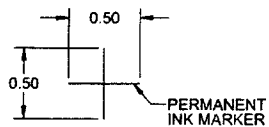
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

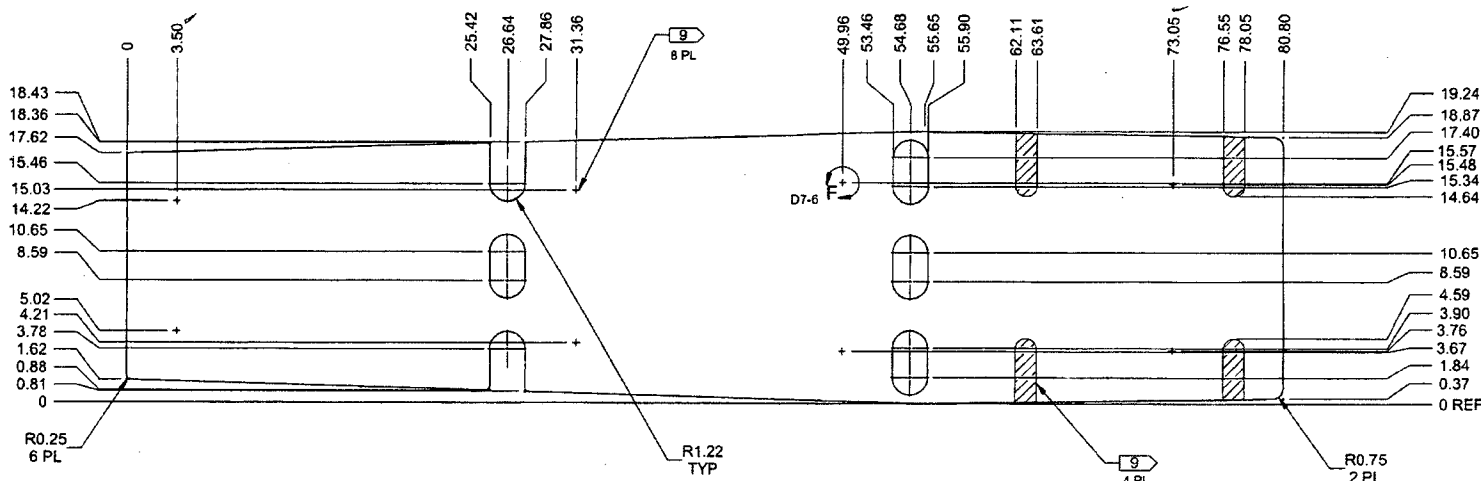
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DETAIL F
NOT TO SCALE
TRIMMED KIT ONLY



D4640-11 FLOOR PROTECTOR
TEXTURED SIDE SHOWN

NOTES:

- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 5.66 lbs (TRIMMED WEIGHT = 5.55 lbs)
- 8) CHECK PER TEMPLATE DT8929
- 9) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER:
- DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER
- TRIM AND REMOVE SHADED AREA

guba

RELEASED
2013-01-10

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4640	SHEET 6 OF 9
APPROVED		TITLE	SCALE
DE APPR.		BAGGAGE PROTECTOR	NTS
DATE	12.12.18	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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